

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017154**Date Inspected:** 11-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing (MT) - Document No's: 006643

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment Retro Plates. The weld designations reviewed are as follows:

1. RETRO-A01-246-001
2. RETRO-A01-246-002
3. RETRO-A01-247-001
4. RETRO-A01-247-002
5. RETRO-A01-242-001
6. RETRO-A01-242-001

Magnetic Particle Testing (MT) - Document No's: 006645

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Segment Retro Plates. The weld designations reviewed are as follows:

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1. RETRO-A02-062-001
2. RETRO-A02-062-002

OBG Segment 12AE

This QA inspector observed ZPMC qualified welding personnel identified as 044772 perform Shielded Metal Arc Welding (SMAW) welding on OBG Segment 12AE, weld joint identified as OBE12B-002 and 003. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P2114-FCM-1.

This QA inspector observed ZPMC qualified welding personnel identified as 044779 perform SMAW welding on OBG Segment 12AE, weld joint identified as OBE12B-004 and 005. ZPMC QC is identified as Mr. Li Ping. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P2114-FCM-1.

Bay 14

This QA inspector observed ZPMC qualified welding personnel identified as 067079 perform Flux Core Arc Welding (FCAW) Welding on OBG Segment 13BE, weld joint identified as KP3008-001-008. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA inspector observed ZPMC qualified welding personnel identified as 066236 perform FCAW Welding on OBG Segment 13BE, weld joint identified as KP3005-001-001, 002. ZPMC QC is identified as Mr. Wang Xu. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

Bay 16

This QA inspector observed ZPMC qualified welding personnel identified as 045143 perform FCAW welding on the Longitudinal Diaphragm Lifting leg of OBG Segment 13BW, weld joint identified LD3032-001-037, 053. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 045280 perform FCAW welding on the Longitudinal Diaphragm Lifting leg of OBG Segment 13BW, weld joint identified LD3035-001-045, 029. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

This QA inspector observed ZPMC qualified welding personnel identified as 040344 perform FCAW welding on the Longitudinal Diaphragm Stiffener of OBG Segment 13CW, weld joint identified LD3033-001-031, 047. ZPMC QC is identified as Mr. Wang Jie. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-Tc-U5-F.

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Bay 19

This QA inspector observed ZPMC qualified welding personnel identified as 062814 perform Shielded Metal Arc Welding (SMAW) welding on Suspender Bracket, repair weld joint identified as SB020-080-004. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair, which is used as per Critical Welding Repair Report (CWR) B-WR1899.

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform FCAW on Bike Path, repair weld joint identified as BK004A1-004-006. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WR14989.

This QA inspector observed ZPMC qualified welding personnel identified as 058792 perform FCAW on Bike Path, repair weld joint identified as BK004A1-004-008. ZPMC QC is identified as Mr. Xu Tao. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G (2F)-FCM-Repair, which is used as per Welding Repair Report (WRR) B-WR14990.

This QA inspector observed ZPMC personnel performing Magnetic Particle Testing (MT) on Stringer Plate of Bike Path. The weld joints are identified as BK004B6-013, BK004B7-013, BK004B6-014 and BK004B7-014. ZPMC QC is identified as Mr. Li Ming Yang. See the attached pictures.

Visual Inspection after Blast

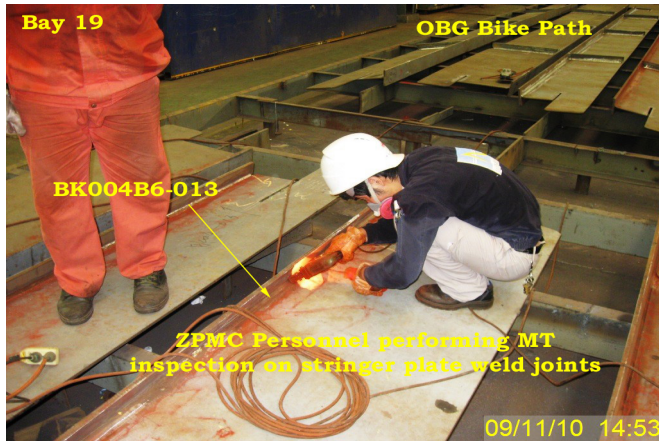
Segment 11BW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 11BW, after the grit blast of the interior components of the deck panel, floor beams and corner assemblies of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: McClendon,Timothy

QA Reviewer